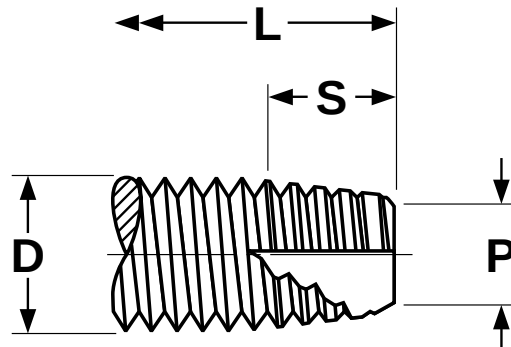


Self-Tapping Screws

Thread Cutting

Type-23



THREADS AND POINTS FOR TYPE 23 THREAD CUTTING SCREWS														ANSI B18.6.4	
Nominal Size or Basic Screw Diameter		Threads Per Inch	D		P		S				L				Minimum Torsional Strength, lb.-in.
			Major Diameter		Point Diameter		Point Taper Length				Determinant Length for Point Taper		Minimum Practical Screw Lengths		
							Short Screws		Long Screws						
			Max	Min	Max	Min	Max	Min	Max	Min	90° Heads	Csk Heads	90° Heads	Csk Heads	
4	.1120	40	.1120	.1061	.087	.078	.088	.062	.112	.088	7/32	1/4	3/16	1/4	13
6	.1380	32	.1380	.1312	.107	.096	.109	.078	.141	.109	1/4	5/16	1/4	5/16	23
8	.1640	32	.1640	.1571	.132	.122	.109	.078	.141	.109	1/4	11/32	1/4	5/16	42
10	.1900	24	.1900	.1818	.148	.135	.146	.104	.188	.146	11/32	7/16	5/16	13/32	56
10	.1900	32	.1900	.1831	.158	.148	.109	.078	.141	.109	1/4	11/32	1/4	5/16	74
12	.2160	24	.2160	.2078	.174	.161	.146	.104	.188	.146	11/32	7/16	5/16	13/32	93
1/4	.2500	20	.2500	.2408	.200	.184	.175	.125	.225	.175	13/32	17/32	3/8	1/2	140
5/16	.3125	18	.3125	.3026	.257	.239	.194	.139	.250	.194	15/32	19/32	7/16	9/16	306
3/8	.3750	16	.3750	.3643	.312	.293	.219	.156	.281	.219	1/2	11/16	15/32	5/8	560
Tolerance on Length			Up to 3/4 in., Incl.: -0.03					Over 3/4 to 1-1/2 in., Incl.: -0.05				Over 1-1/2 in.: -0.06			

Description	A thread cutting screw with machine screw thread pitch, a blunt point, tapered entering threads, a single wide cutting edge, and a chip cavity.
Applications/ Advantages	For cast iron and zinc, aluminum die castings, and plastics. Provides excellent chip clearing with minimum tightening torques.
Material	AISI 1016 - 1024 or equivalent steel.
Heat Treatment	Screws shall be quenched in liquid and then tempered by reheating to 650°F minimum.
Surface Hardness	Rockwell C45 minimum
Case Depth	No. 4 thru 6 diameter: .002 - .007 No. 8 thru 12 diameter: .004 - .009 1/4" diameter and larger: .005 - .011
Core Hardness (after tempering)	Rockwell C28 - 38
Plating	See Appendix-A for plating information.